



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.3701
Job Sheet 186928



Part No: 647.3701

Job Qty: 1 ea

Part Name: 412 Cable Cutter System, Standard



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 647.3700 REV.A IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.26 as per ecr 14-214 DD VERF:JLM IPP REV:C AS PER REV NC3 15.03.18 JLM VERIFIED BY:DD IPP REV:D 18.01.19 AS PER DWG REV.A DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Stores/Pkg-2		NOV 2 6 2018
110	Packaging	1 pcs	12/7/18	12/7/18	0.00	0.00	Packaging1-1	DAS 69	NOV 2 6 2018
120	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC4	69	DEC 0 6 2018
125	DC	1 pcs	12/7/18	12/7/18	0.00	0.00	DC	9-89 DAS 69	DEC 0 6 2018
130	Packaging	1 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-1	69	DEC 0 6 2018
140	QC21-FG	1 Ea	12/7/18	12/7/18	0.00	0.00	QC21	9-89	DEC 0 6 2018

Part Op 125 - Photocopy bluefile & type labels per PPP 647.3701
Descriptions: 130 - Identify and pack for shipping as per PPP 647.3701

DAS 21 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	512 3705
601.2045	RTV (LOCTITE 598)	1 Ea (1 ea)	90-Start up Operation	5084065
601.3083	Adhesive Rubber Seal	1 Ea (1 ea)	90-Start up Operation	5126923 5135553
647.3801	412 Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5064985
647.3803	Lower Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	7145480
647.3903	Deflector Assembly	1 Ea (1 ea)	90-Start up Operation	5119404
647.4010	Wiper Deflector RH	1 Ea (1 ea)	90-Start up Operation	F158472
647.4011	Wiper Deflector LH	1 Ea (1 ea)	90-Start up Operation	5062598
647.4110	Doubler	1 Ea (1 ea)	90-Start up Operation	5004312
647.4111	Doubler	1 Ea (1 ea)	90-Start up Operation	5108301
647.4112	Clip	1 Ea (1 ea)	90-Start up Operation	3059110
647.4113	Clip	1 Ea (1 ea)	90-Start up Operation	F163487
647.4114	Shim	2 Ea (2 ea)	90-Start up Operation	5026930
647.4115	Shim	2 Ea (2 ea)	90-Start up Operation	5026932
647.4116	Shim	1 Ea (1 ea)	90-Start up Operation	5058999
647.4210	Bracket LH	1 Ea (1 ea)	90-Start up Operation	F161755
647.4211	Bracket RH	1 Ea (1 ea)	90-Start up Operation	F161784
647.4310	LH Lower Strut	1 Ea (1 ea)	90-Start up Operation	5060797
647.4311	RH Lower Strut	1 Ea (1 ea)	90-Start up Operation	5107320
647.4312	LH Upper Strut	1 Ea (1 ea)	90-Start up Operation	F162442
647.4313	RH Upper Strut	1 Ea (1 ea)	90-Start up Operation	5026532

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date :		Step #:		QTY Effective :						MRB (QSI042) Approval	
Description Work Order Deviation				Disposition						Completed By	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S131603 Part: 647.3701 Job No: 186928 Serial No/Batch: S131603 Revision: A Inspector: Exp Date: Instructions: FAA STC SR02289LA 17/83/07, 16, 15 STC LOA RI										Lead hand / Supervisor Approval Verification	
										QC / QA Coordinator Approval	
Root Cause		Pr		Be		Ce		Ci		Positioned Wrong	
Environment ☐		☐ No Re-verification		☐		☐		☐		☐ Outside Dimensions	
Design ☐		☐ Operator		☐		☐		☐		☐ Over/Under tolerance	
Doc/Data ☐		☐ Offset/Setup		☐		☐		☐		☐ Part Incorrect	
Equip/Tooling ☐		☐ Supplier		☐		☐		☐		☐ Part Lost/Missing	
Handling/Pre ☐		☐ Training		☐		☐		☐		☐ Part Moved	
Material ☐		☐ Use for Testing		☐		☐		☐		☐ Drawing	
Internal Transport ☐		☐ Poor Information		☐		☐		☐		☐ Finish	
Tribal Knowledge ☐		☐ Rushing		☐ Heat Treat		☐ Cut Too Short		☐ Mislabeled		☐ Misread	
LOA ☐		☐ Product Improvement		☐ Wave/Twist in Tube		☐ Instructions Incomplete/Unclear		☐ Fit/Function		☐ Turning Sequence	
Substation ☐		☐ Process Improvement		☐ Marks/Chatter		☐ Drill Holes		☐ Misaligned/off center			
Past Expiry Date ☐		☐ Manufacturing Process									
Misidentified ☐		☐ Past Due		OTHER :							

AN3-11A	Bolt	8 Ea (8 ea)	90-Start up Operation	5098034
AN3-4A	Bolt	3 Ea (3 ea)	90-Start up Operation	5112901
AN3C10A	Bolt	2 Ea (2 ea)	90-Start up Operation	5019323
CCR264SS-3-03	Cherry Rivet	16 Ea (16 ea)	90-Start up Operation	5082912
CCR264SS3-04	Rivet	12 Ea (12 ea)	90-Start up Operation	5120512
CR3212-4-2	Cherry Rivet	12 Ea (12 ea)	90-Start up Operation	5102069
CR3212-4-3	Cherry Rivet	17 Ea (17 ea)	90-Start up Operation	5053949
CR3212-4-4	Cherry Rivet	4 Ea (4 ea)	90-Start up Operation	5045669
CR3213-4-2	Cherry Rivet	13 Ea (13 ea)	90-Start up Operation	5116951
CR3213-4-3	Rivet, Cherry	32 Ea (32 ea)	90-Start up Operation	5098033
CR3213-4-4	Rivet, Cherry	19 Ea (19 ea)	90-Start up Operation	5027749
CR3213-4-5	Rivet	42 Ea (42 ea)	90-Start up Operation	5018325 x 41
CR3213-4-8	Rivet	4 Ea (4 ea)	90-Start up Operation	5067267
MS21042L08	Use Ms21042L08	18 Ea (18 ea)	90-Start up Operation	5100409
MS21042-3	Nut	79 Ea (79 ea)	90-Start up Operation	5108577
MS21047-3	Nut Plate	4 Ea (4 ea)	90-Start up Operation	5103942
MS21047L06	Nut Plate	6 Ea (6 ea)	90-Start up Operation	51138408 x 5 5114918 x 1
MS21047L08	Nut Plate	6 Ea (6 ea)	90-Start up Operation	5107432
MS21071L3	Anchor Nut	4 pcs (4 ea)	90-Start up Operation	5055950
MS24694-C53	Screw	8 Ea (8 ea)	90-Start up Operation	51132951-2
MS24694-S49	Screw	1 Ea (1 ea)	90-Start up Operation	51129702
MS27039-08-08	Screw	16 Ea (16 ea)	90-Start up Operation	5053952
MS27039-08-11	Screw	2 Ea (2 ea)	90-Start up Operation	51138336 x 10
MS27039-1-07	Screw	12 Ea (12 ea)	90-Start up Operation	5111086
MS27039-1-09	Screw	14 Ea (14 ea)	90-Start up Operation	5017101
MS27039-1-10	Screw	42 Ea (42 ea)	90-Start up Operation	5071834
NAS1149F0332P	Washer	157 Ea (157 ea)	90-Start up Operation	5109991 x 44 5131201 x 113
NAS1149FN832P	Washer	34 Ea (34 ea)	90-Start up Operation	5107796
647.4410	Rail	1 Ea (1 ea)	90-Start up Operation	5155358

601.3083

5135353 x 1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.1012	1	21	0
	601.2045	1	19	0
	601.3083	1	4	0
	647.3801	1	1	0
	647.3803	1	1	0
	647.3903	1	2	0
	647.4010	1	7	0
	647.4011	1	5	0
	647.4110	1	1	0
	647.4111	1	8	0
	647.4112	1	9	0
	647.4113	1	3	0
	647.4114	2	3	0
	647.4115	2	3	0
	647.4116	1	14	0
	647.4210	1	6	0
	647.4211	1	6	0
	647.4310	1	9	0
	647.4311	1	9	0
	647.4312	1	2	0
	647.4313	1	2	0
	647.4410	1	1	0
	AN3-11A	8	275	0
	AN3-4A	3	300	0
	AN3C10A	2	56	0
	CCR264SS-3-03	16	502	0
	CCR264SS3-04	12	104	0
	CR3212-4-2	12	74	0
	CR3212-4-3	17	32	0
	CR3212-4-4	4	290	0
	CR3213-4-2	13	112	0
	CR3213-4-3	32	204	0
	CR3213-4-4	19	518	0
	CR3213-4-5	42	118	0
	CR3213-4-8	4	77	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															
OTHER : ☐																									

MS21042-08	18	1	0
MS21042-3	79	134	0
MS21047-3	4	382	0
MS21047L06	6	55	0
MS21047L08	6	48	0
MS21071L3	4	53	0
MS24694-C53	8	27	0
MS24694-S49	1	183	0
MS27039-08-08	16	29	0
MS27039-08-11	2	1,173	0
MS27039-1-07	12	197	0
MS27039-1-09	14	66	0
MS27039-1-10	42	241	0
NAS1149F0332P	157	847	0
NAS1149FN832P	34	1,471	0

Part Specifications

Specifications could not be found.

Plex 11/22/18 2:49 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

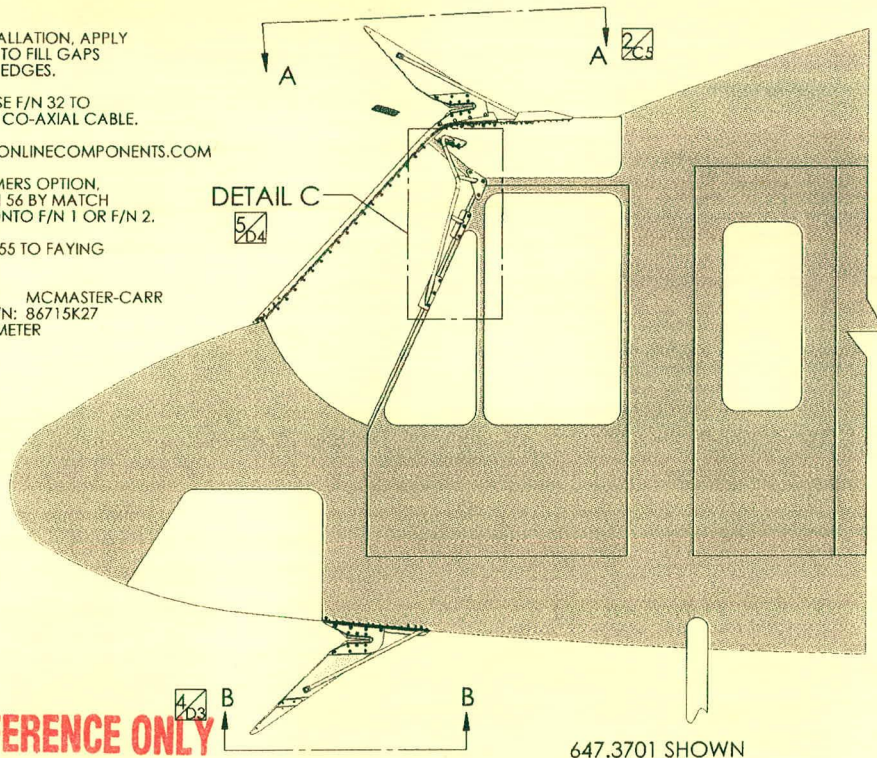
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
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Misidentified ☐	Past Due ☐																								

REFERENCE ONLY

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NOTES:

- 1 AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.
- 2 IF REQD, USE F/N 32 TO CONNECT CO-AXIAL CABLE.
- 3 VENDOR : ONLINECOMPONENTS.COM
- 4 AT CUSTOMERS OPTION, INSTALL F/N 56 BY MATCH DRILLING ONTO F/N 1 OR F/N 2.
- 5 APPLY F/N 55 TO FAYING SURFACES.
- 6 VENDOR : MCMMASTER-CARR
VENDOR P/N: 86715K27
60A DUROMETER



REFERENCE ONLY

647.3701 SHOWN

REF	REF	REF	56	647.5701		LOCITE 598	
A/R	A/R	A/R	A/R	55	601.2045	RTV	PR-1425 CLASS B
A/R	A/R	A/R	A/R	54	601.1012	SEALANT	MIL-R-3065
2	2	2	2	53	601.3083	ADHESIVE RUBBER SEAL	MS21071-3
4	4	4	4	52	601.2957	NUTPLATE	MS21047-3
4	4	4	4	51	600.0795	NUTPLATE	MS21047-3
6	6	6	6	50	601.3066	NUTPLATE	MS21047-08
6	6	6	6	49	601.3065		MS21047-06
18	18	18	18	48	601.2973	LOCKNUT	MS21042-08
79	79	79	79	47	601.2943	LOCKNUT	MS21042-3
4	4	4	4	46	601.2364	CHERRY RIVET	CR3213-4-8
28	28	42	42	45	601.1183	CHERRY RIVET	CR3213-4-5
16	16	19	19	44	601.1915	CHERRY RIVET	CR3213-4-4
24	24	32	32	43	601.0790	CHERRY RIVET	CR3213-4-3
3704	3703	3702	3701	FIND	PART #	DESCRIPTION	MAT'L
							SPEC.

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price

Calls for 6

[illegible]

REFERENCE ONLY

100-100000-100000